

Work Order ID 70002

Wednesday, May 25, 2011 11:30:36 AM



Page 1

Item ID: D3084-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3084	C

100

0.00



BAND SAW

Small Fab

Memo

0.00

Small Fab

1- Punch per Dwg. D3084 and spec control dwg D2638
2-Debur

SB 11/06/01
EP 11/06/01

(4)

(4)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 11/06/01

(x4)

120

0.00



Weld per dwg A/R Aluminum rod Batch: 114703

Large Fab

Memo

0.00

Large Fab

1- Weld ends per dwg
2- Grind flush

AE 11.06.01

AE 11.06.01

4

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70002

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Page 2

Item ID: D3084-3

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Item Name: Strut

Start Date: 5/25/2011 Start Qty: 4.00

Required Date: 6/3/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect visual per QSI004- Fusion Welds

QC10

Memo

0.00

0.00

8 ul 06/02

Pto →

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 ul 06/02

(44)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

OVEN TEMPERATURE:

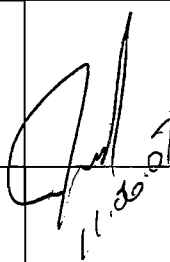

FINISH TIME:

9:15
320 OF
9:45

0.00

4x ✓ M-11/06/02

M 115128

W/O: 70002		WORK ORDER CHANGES						
DATE	STEP	Perm. Chan.	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
W/O: 70002	# 130		change step to QC inspection					

Part No: D3084-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 70002

Wednesday, May 25, 2011 11:30:36 AM

Page 3

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Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 5/25/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H BR 11-6-2

170

Identify as per dwg & Stock Location: 271

0.00



Packaging

Memo

0.00

Packaging

11/6/25 J

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/7 J
MF
11-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 11:30:42 AM

Page 1

Work Order ID: 70002

Parent Item: D3084-3

Parent Item Name: Strut



Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC
10.10.13 AS PER DWG REV.C DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.750W.058

Purchased

No

100

f

181.2500

2.4833

10.456



20 11/26/01

6061-T6 RD Tube .750 x.058W

Location

Loc Qty

Loc Code

MAT015

181.25

10099

24

112652

157.25

13

W/O:		WORK ORDER CHANGES					
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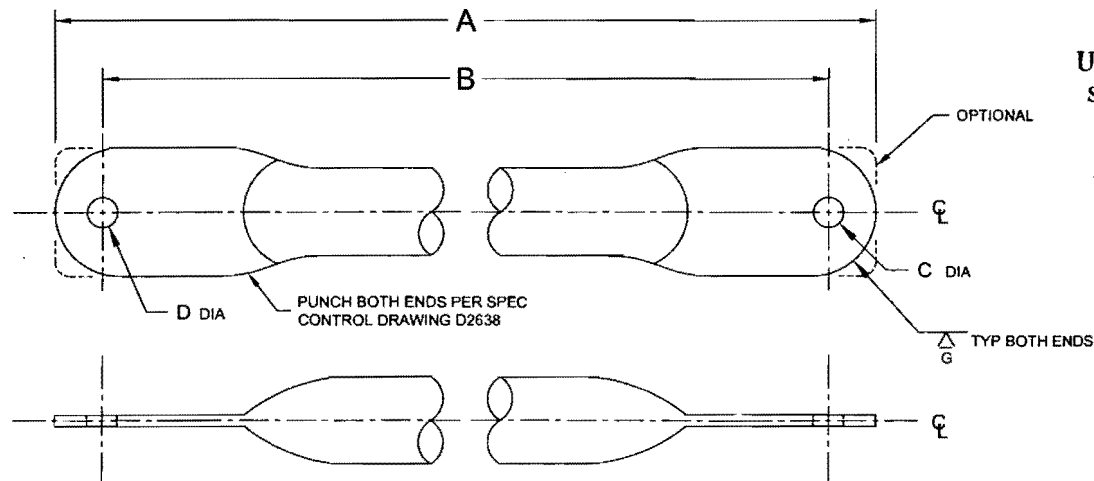
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10002

PHI-05-2



	A	B	C	D	WEIGHT	FINISH
D3084-1	37.18	36.38	0.257	0.323	0.46 lbs	WHITE POWDER COAT (4.3.5.1) PER DART QSI 4.3
D3084-3	29.80	29.00	0.257	0.257	0.37 lbs	GREY POWDER COAT (4.3.5.6) PER DART QSI 4.3

D3084-XX STRUT
MAKE FROM DT3084-XX
(XX IS THE RESPECTIVE DASH NUMBER)

RELEASED
2010-10-13

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 SEAMLESS TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8
REF DART SPEC M6061T6T0.750W.058
- 2) FINISH: SEE TABLE FOR POWDER COAT COLOR
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE.
- 7) WEIGHT: SEE TABLE
- 8) WELD PER DART QSI 004.



C	RMV CHEM CONV (NCR 10-059, ZN A6-1)	CP	10.05.18
B	DRAWING REFORMAT - 3 ADDED. NOTES UPDATED	JPH	10.04.13
A	NEW ISSUE	CP	02.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3084	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STRUT	NTS
DATE	10.05.18	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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